

[illegible]

Job Number:

1.0 **M304S22GA™** 304/316 .032 Sheet

Comment: Qty.: 0.8442 sf(s)/Unit Total : 3.3768 sf(s)

304/316 .032 Sheet

Batch

2.0 WATER JET FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3245 *****prog.D3245-1/-2*****

Dwg Rev: 3

Prog Rev: B

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------

Comment: NC BRAKE

Deburr if necessary

☞ sink as per Dwg D3245

Form D3245-1 as per Dwg D3245 Identify as D3245-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3245-2 PAR #: N/A Fault Category: Prod / FAB ASSY ^{med & small} NCR: Yes No DQA: A Date: 09/03/06
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: P Date: 09/03/06

NCR: <u>46172</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/03/05</u>	<u>5</u>	<u>One hole countersunk to deep RC: Process</u>	<u>[Signature]</u> <u>09/03/05</u>	<u>Sill with weld M# <u>108335</u> redrill re countersunk</u>	<u>[Signature]</u> <u>09/03/04</u> <u>09/03/05</u>	<u>S</u> <u>02/03/05</u>	<u>[Signature]</u> <u>09/03/05</u>	<u>[Signature]</u> <u>09/03/05</u>

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:23:55 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 46172

Part Number: D32452

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/03/25 (KQ)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57233A 09/03/25 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/25 A

Job Completion



MF 09-03-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46172
Description: Doubler		Part Number: D3245-2
Inspection Dwg: D3245	Rev: B	Page 1 of 1

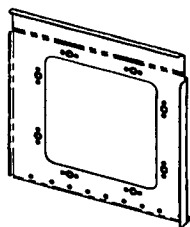
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.102	✓			
Ø0.375	+0.006/-0.001	.378	✓			
0.400	+/-0.010	.401	✓			
1.117	+/-0.010	1.117	✓			
1.150	+/-0.010	1.149	✓			
1.000	+/-0.010	1.000	✓			
10.57	+/-0.030	10.58	✓			
9.500	+/-0.010	9.496	✓			
8.350	+/-0.010	8.343	✓			
3.500	+/-0.010	3.497	✓			
9.40	+/-0.030	9.396	✓			
11.04	+/-0.030	11.032	✓			
6.200	+/-0.010	6.198	✓			
2.230	+/-0.010	2.236	✓			
2.020	+/-0.010	2.026	✓			
.032	± .010	.029	✓			

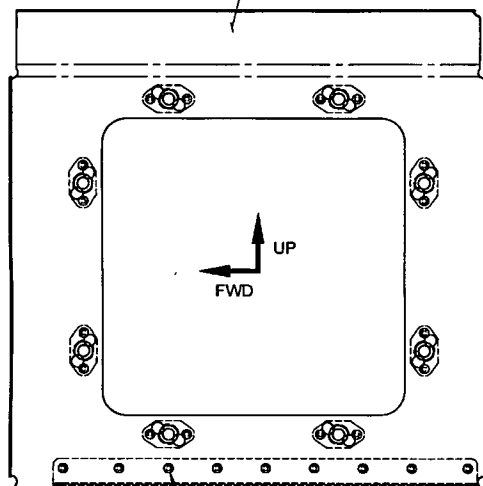
Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-3-13	Date: 09/03/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	



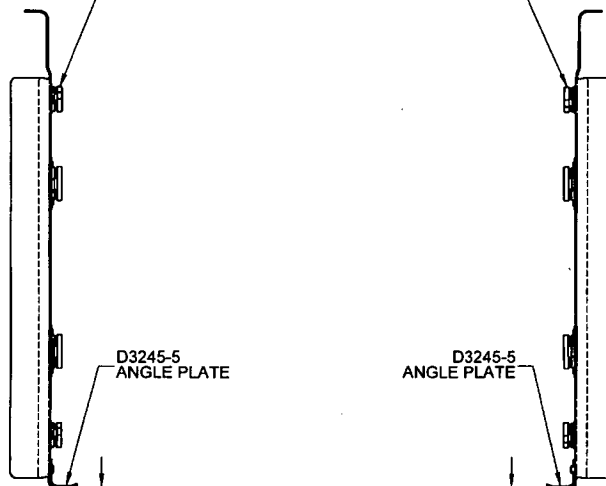
D3245-1
PANEL

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



MS20615M3-3 RIVET
(9 PLACES)

D3245-041 ACCESS PANEL ASSEMBLY

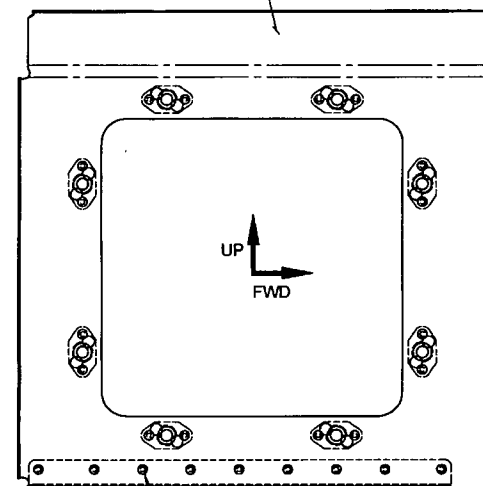
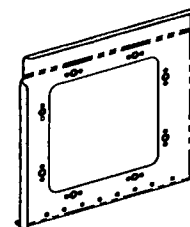


0.032
GAP

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-2
PANEL



MS20615M3-3 RIVET
(9 PLACES)

D3245-042 ACCESS PANEL ASSEMBLY

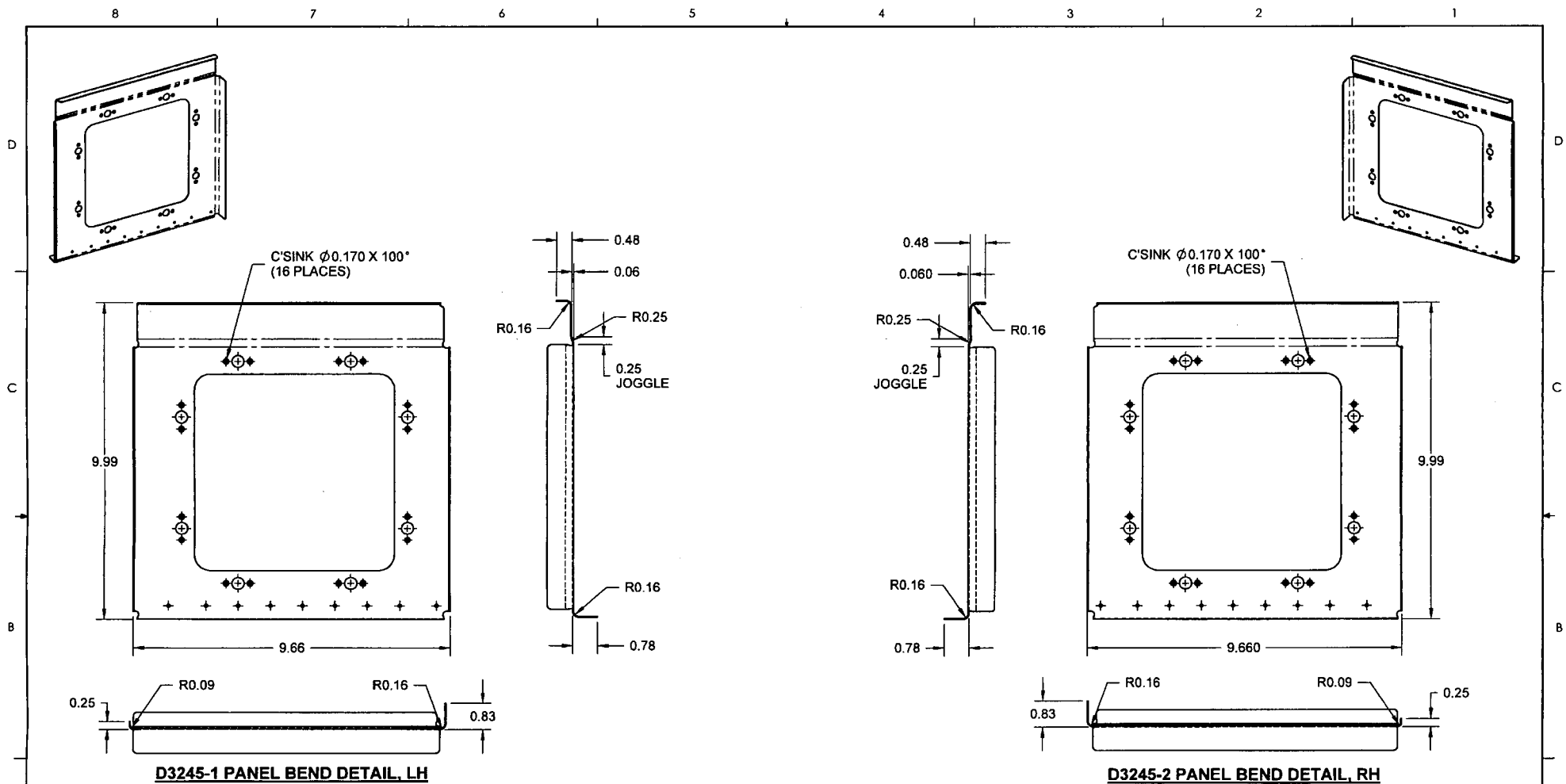
RELEASED
07-10-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

B	REMOVE Ø0.204 HOLES FROM D3245-1/-2. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	D3245	SHEET 1 OF 7
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	ACCESS PANEL ASSEMBLY	1:2.5
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.10.02		

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 14112



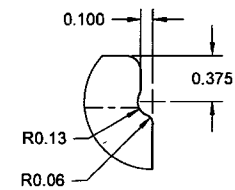
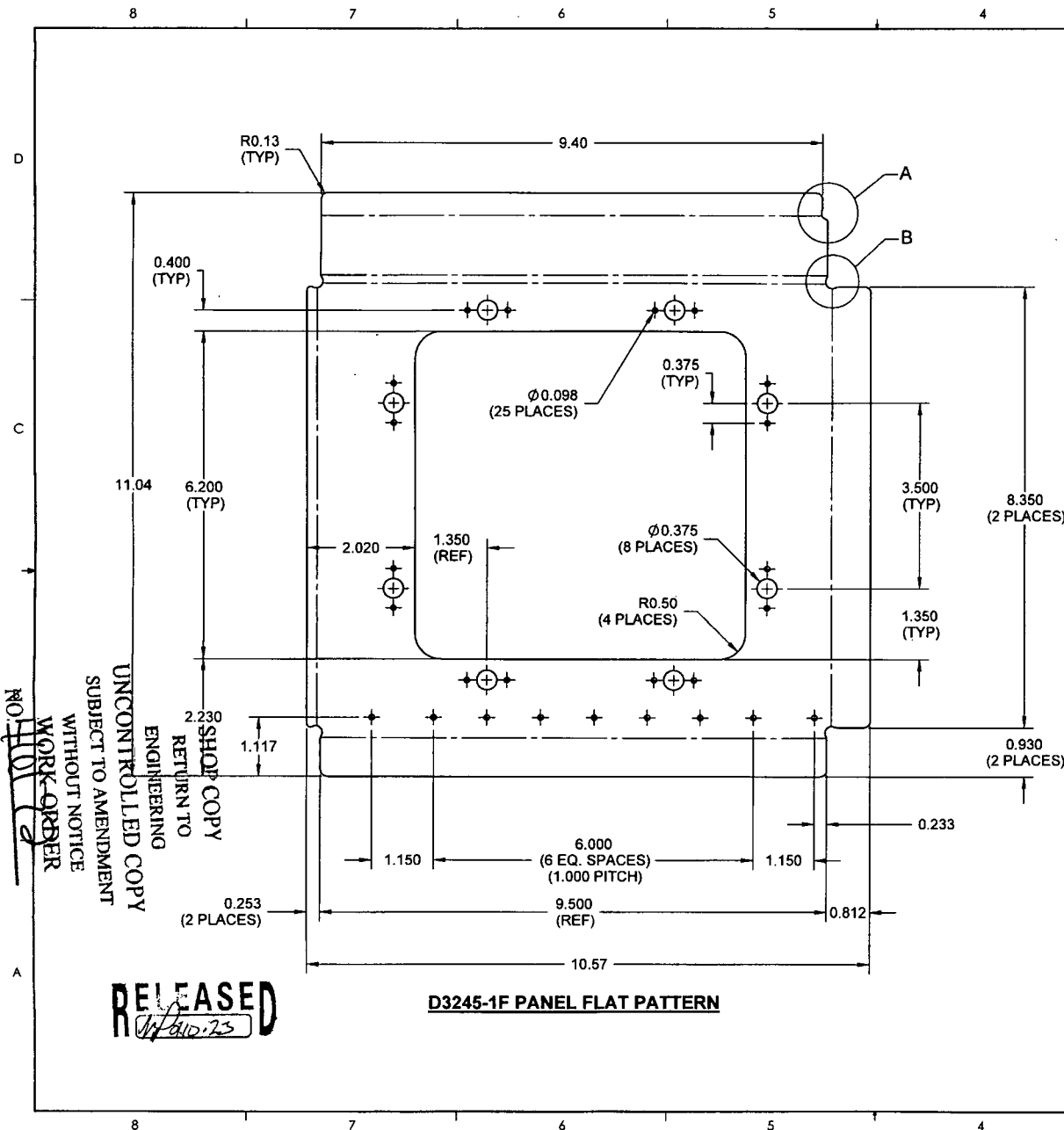
RELEASED
07-10-23

NOTES:

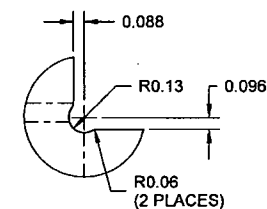
- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

NO. 10112
WORK ORDER
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SHOP COPY

DESIGN	<i>TH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO. D3245	REV. B
MFG. APPR.	<i>NS</i>	SHEET 2 OF 7	
APPROVED	<i>NS</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	ACCESS PANEL ASSEMBLY	1:3
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DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
(TYP. 4 PLACES)
SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
(0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	#	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3245	SHEET 4 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY	1:2
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D3245-1F PANEL FLAT PATTERN

RELEASED
7/10/02

NO. 1012
WORK ORDER
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2.230

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries